

Date: Friday, 12/06/2009 9:54:07 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STRUT
<b>Job Number</b> : 48533	
<b>Estimate Number</b> : 10272	
<b>P.O. Number</b> :	<b>Part Number</b> : D2562001
<b>This Issue</b> : 12/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2562 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 48108	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 24/06/2009 <b>Qty:</b> 3-8 Um: Each
<b>Checked &amp; Approved By</b> : <u>Julie Dawson</u>	
<b>Comment</b> : Est F 02.04.15 Added dwg Rev.B1 NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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**Comment:** Qty.: 1.7920 f(s)/Unit Total : 14.3363 f(s)  
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall  
 Batch M111097

m.l. 09/06/23

2.0	BRAKE NC	NC BRAKE
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(3X)

**Comment:** NC BRAKE  
 Punch to length as per Dwg D2562

m.l. 09/06/23

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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(3X)

**Comment:** SMALL/MED FAB RESOURCE  
 1- Bend end as per Dwg D2562 Angle "D"  
 2-Deburr

m.l. 09/06/23

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 09/06/23 (X3)

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 3:20pm  
 OVEN TEMPERATURE: 320°F  
 FINISH TIME: 3:50pm

950 09-06-23 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:54:07 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 48533

Part Number: D2562001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(3X)

Comment: INSPECT POWDER COAT

*M. H.*

09/06/23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(3X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *264*

9/6/23

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 209/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

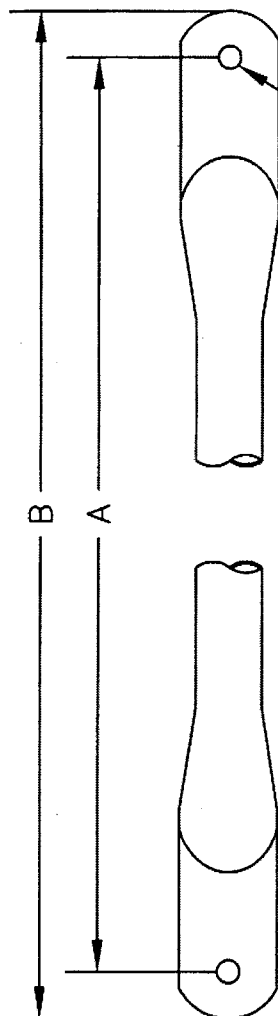
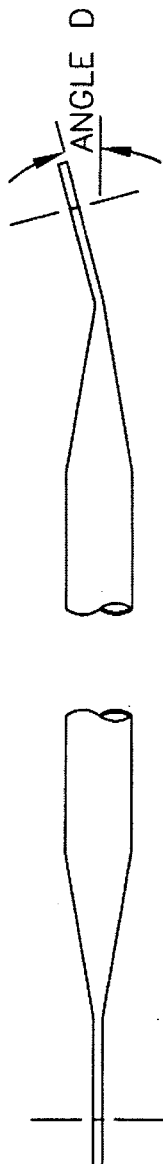
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18		TITLE STRUT	SCALE 1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48533

GENERAL NOTES  
1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TRO.500W.035)  
ENSURE SEAMLESS TUBE IS USED  
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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